

1547
Work Order ID 102674

Monday, June 10, 2013 9:53:19 AM

102674

Page 1

Item ID: D3256-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Panel

Start Date: 6/10/2013 Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/14/2013 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *13-6-10* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3256

E

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3256

304.030"

Dwg Rev: *15*

Prog Rev: *15*

2-Deburr if necessary

8

0

Jm 13-6-10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

8

0

Jm 13-6-10

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8

13-6-10

DAS
00
2.3

Work Order ID 102674

102674

Page 2

Monday, June 10, 2013 9:53:19 AM

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N9000040100

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Item Name: Panel

Stop ***NS2***

Start Date: 6/10/2013 Start Qty: 8.00 ***8***

Cust Item ID:

Required Date: 6/14/2013 Req'd Qty: 8.00 ***8***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Form using D3256-1T2

8

8

FF
13-06-11

140

140

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

2013
6
12
B G R

8

150

150

Packaging

Identify as per dwg & Stock Location: ST 187

0.00

Memo

0.00

Packaging

8x

M.D. 13-06-12

Work Order ID 102674

Monday, June 10, 2013 9:53:19 AM

102674

Page 3

Item ID: D3256-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Panel

Stop ***NS2***

Start Date: 6/10/2013 Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/14/2013 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MCJ 13-06-12

MK

13-6-12

Picklist Print

Monday, June 10, 2013 9:53:16 AM

Page 1

Work Order ID: 102674

Parent Item: D3256-1

Parent Item Name: Panel

Start Date: 6/10/2013

Required Date: 6/14/2013

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-09-28 EC verified by:DD
IPP Rev:b ECN 1052 07-10-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	181.4800	0.987	8.3115789 9.0			Jm13-6-10
304/316 .032 Sheet													

Location

Loc Qty

Loc Code

MAT020

181.48

118271

10.76

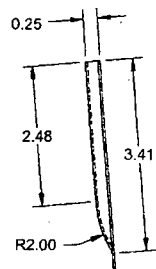
120866

55.47

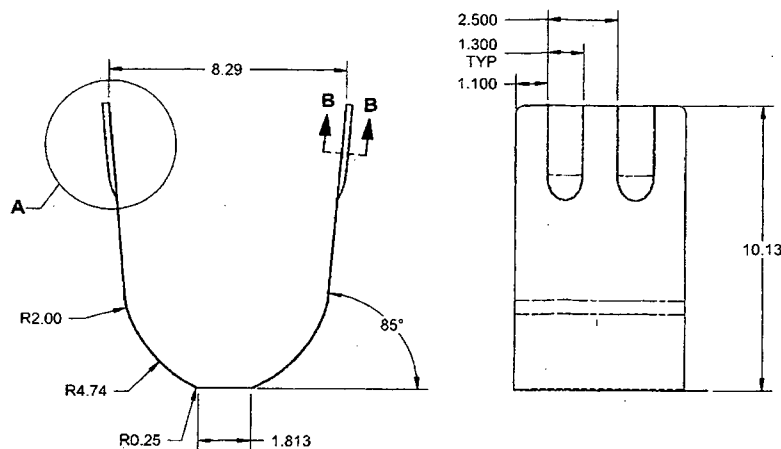
121889

115.25

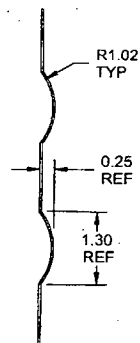
121889



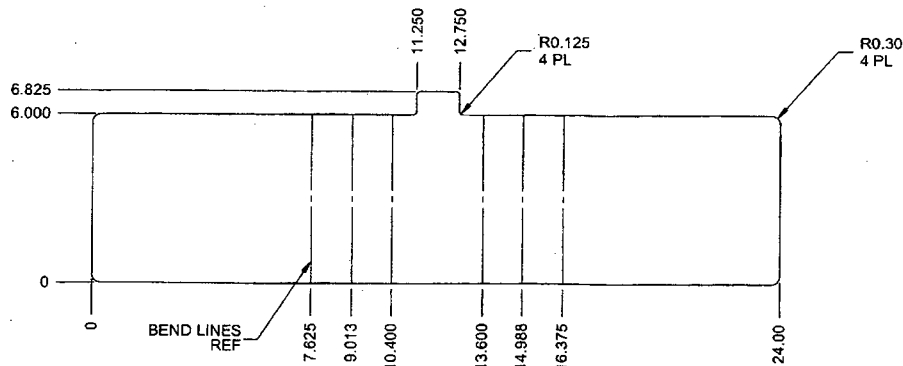
DETAIL A
SCALE 2X



D3256-1 ACCESS PANEL
(MAKE FROM D3256-1F)



SECTION B-B
SCALE 2X
(VIEW ROTATED)



D3256-1F FLAT PATTERN

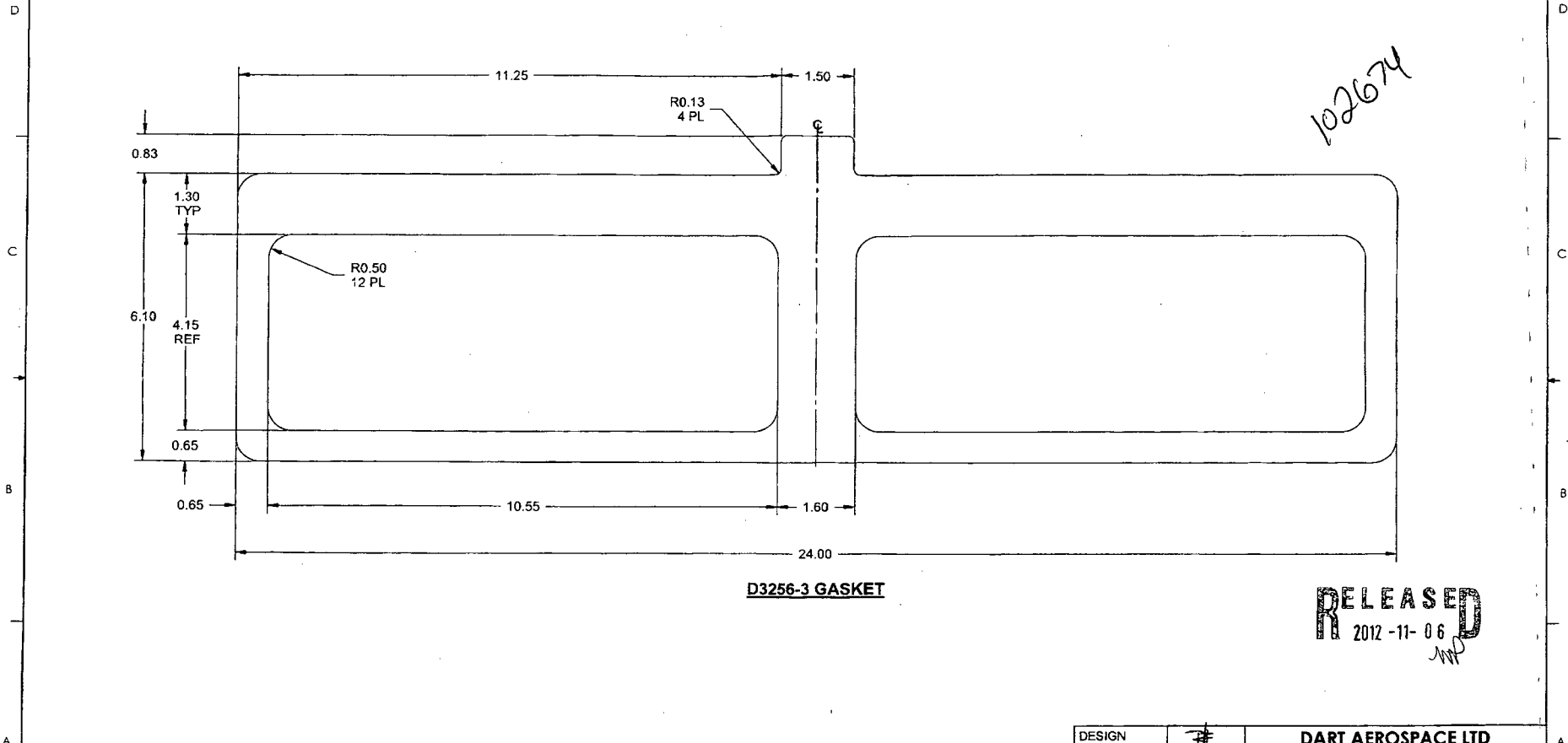
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 0.032 THICK
PER MIL-S-5019 OR AMS 5513/AMS 5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S22GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3256-1" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 1.37 lbs

RELEASED
2012-11-06
MT

E	CHANGED MATERIAL FOR D3256-3. REASON: PROCUREMENT, REF CAR12-69.	MB	12.10.16
D	UPDATED TO COMPLY WITH QSI 043; REMOVED "FORM JOGGLE PER D3256-1T1" AND "FORM PER D3256-1T2" (SEE PREVIOUS REV FOR REFERENCE); 6.825 WAS 6.450 (ZN B7-1); 0.83 WAS 0.45 (ZN C8-2). REASON: PAR11-124.	MB	11.10.25
C	D3256-041 ELIMINATED; REMOVED (QTY.22) 0.128 HOLES FROM D3256-1F AND D3256-3 GASKET. INSTRUCTIONS TO DRILL HOLES AND INSTALL D3256-3 GASKET ARE NOW PART OF THE INSTALLATION INSTRUCTIONS	MB	07.09.28
B	D3256-3 DIM 1.30 WAS 0.65	RF	05.06.27
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3256 ACCESS PANEL <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY COMPANY AND NOT TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	REV. E SHEET 1 OF 2 SCALE NTS	
DATE	12.10.16		

8 7 6 5 4 3 2 1



D3256-3 GASKET

RELEASED
2012-11-06
MP

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, 0.060 THICK
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

DESIGN	#	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3256	REV. E
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL	NTS.
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8 7 6 5 4 3 2 1

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue P/O D3256-041	KJ/JLM	
B	08.09.04	Dimensions removed	KJ/DD	
C	12.05.14	Dimensions updated per Dwg Rev D	KJ	
D	13.05.08	Dimensions updated per Dwg Rev E	KJ	